

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Vallejo, CA 94592-1133  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010290**Date Inspected:** 21-Nov-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	Chen Ying Xin, Gong Liang Zhu			<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>
<b>Inspected CWI report:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
				<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>

**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This Quality Assurance (QA) Inspector observed the following work in progress:

Bay 10

SMAW welding of weld joint 64A located on ED1-STSA3-2-109M-2.

Welder is identified as 040333. ZPMC CWI is identified as Mr. Chen Ying Xin.

The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U5b-1.

SMAW welding of weld joint 28 located on ND1-A6002-10.

Welder is identified as 037840. ZPMC CWI is identified as Mr. Chen Ying Xin.

The welding variables recorded by QC appeared to comply with WPS-B-T-2113.

SMAW welding of weld joint 24B located on ED1-STSA3-2-89M-1.

Welder is identified as 040582. ZPMC CWI is identified as Mr. Chen Ying Xin.

The welding variables recorded by QC appeared to comply with WPS-B-T-2212-Tc-U5b.

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The welding variables recorded by QC appeared to comply with WPS-B-T-2231-Tc-U5-F.

The welding variables recorded by QC appeared to comply with WPS-B-T-2231-Tc-U5-F.

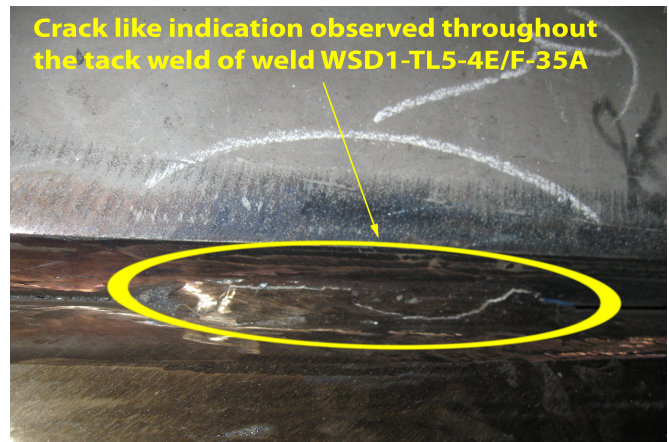
The welding variables recorded by QC appeared to comply with WPS-B-T-4332-Tc-P5-F.

The attached photographs provide additional detail.

**Crack like indication  
observed on tack weld**

**East Tower lift 5  
skin "D"**

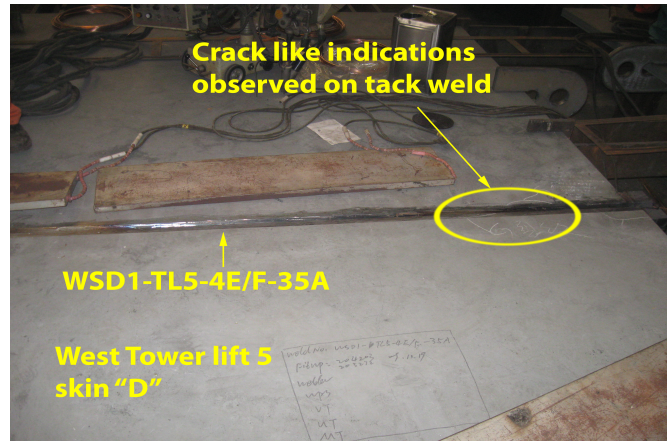
Inspected by: ESDI-TLS-2C / -24A  
Date: 07/10/2018  
Inspector: [Signature]  
Inspector: [Signature]





# WELDING INSPECTION REPORT

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## Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 134-8257-0045, who represents the Office of Structural Materials for your project.

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## WELDING INSPECTION REPORT

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**Inspected By:** Gaikwad,Umesh

Quality Assurance Inspector

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**Reviewed By:** Clifford,William

QA Reviewer